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(54) Title: **METHOD AND DEVICE FOR THE PRODUCTION  
OF FILLED AND SEALED CONTAINERS**

## Field of the Invention

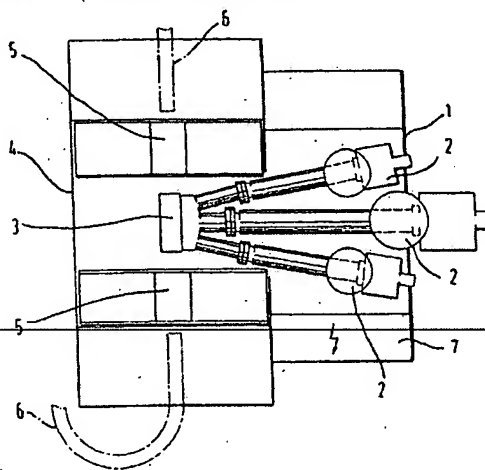
The present invention relates to a method and device for the production of filled and sealed containers and a device for executing such method.

## Background of the Invention

The previously known process of filling and sealing



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(57) Abstract: The invention relates to a method and to a device for the production of filled and sealed containers. According to the invention, a) a plastic tube is extruded, b) at least one container which is impermeable to vapour and which is provided with one filling opening is formed from said plastic tube, c) the filling product is introduced into said container through the filling opening and subsequently d) the filling opening is sealed by welding. The tube is made of at least one layer which makes the container impermeable to oxygen.

[Fortsetzung auf der nächsten Seite]

containers

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~~Reference is made for an explanation of the two letter codes and the other abbreviations to the Guidance Notes on Codes and Abbreviations in the front section of each regular PCT Gazette edition.~~

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### Method and Device for the Production of Filled and Sealed Containers

~~\_\_\_\_\_ The invention relates to a method and device for the production of filled and sealed containers having the features of the preamble of claim 1, and a device for executing such a process.~~

~~\_\_\_\_\_ The known process of the initially mentioned type makes it possible to economically produce, fill, and seal containers, even under aseptic conditions. It is therefore widely used. In all cases in which the contents are sensitive to oxygen, it is however necessary to provide either the container with repackaging or to use glass containers. Both alternatives greatly increase production costs.~~

### Summary of the Invention

~~\_\_\_\_\_ An~~ Therefore the object of the present invention is to provide a process of filling and sealing containers ~~devise a process of the initially mentioned type which can also be used when the contents are sensitive to oxygen.~~

~~-This object is achieved by a process with the features specified in which claim 1.~~

\_\_\_\_\_When specifically the extruded tube is formed from at least one layer which makes the container impermeable to oxygen when the contents are sensitive to oxygen. It, it is then not necessary to produce a blocking layer for oxygen by ~~means of~~ additional repackaging or using to ~~use~~ a glass container.

If this layer is also able to meet other requirements required for which are imposed on the wall of the container, it is not necessary to provide coextrusion of at least two layers. In many cases, however, to meet the imposed requirements and/or for reasons of economy, it is advantageous to form the tube by coextrusion from two or more layers ~~which can then consist of~~ materials with different properties.

~~With previously~~ ~~Since with known machines for producing filled and sealed~~ containers, only tubes which have consist of a single layer can be extruded. ~~Another, the object of~~ the present invention is to provide also to devise a device which economically allows coextrusion.

~~This additional object is achieved by a device where with the features specified in claim 1.~~

~~The assignment of the extrusion head and the pertinent extruder on the one hand and~~ of the blow-fill-seal means on the other hand are assigned to separate racks. Such assignment on ~~the one hand~~ makes it possible to easily accommodate the increased number of components. Different On the other hand, in this way different extrusion units can then be combined with different blow-fill-seal means, enabling adaptation to different requirements without difficulty.

For purposes of the highest degree of flexibility, it is furthermore advantageous to make the control cabinet necessary for the power supply and control likewise as a separate unit. The separate unit which can be set up in a location wherever this is especially advantageous with respect to available space.

Other objects, advantages and salient features of the present invention will become apparent from the following detailed description, which, taken in conjunction with the annexed drawings, discloses a preferred embodiment of the present invention ~~The invention will be~~ detailed below using one exemplary embodiment of the device as claimed in the invention shown in the drawings.

### Brief Description of the Drawings

Referring to the drawings which form a part of this disclosure:

FIG. 1 ~~is~~ shows a side elevational view of a container filling and sealing device according to an exemplary embodiment of the present invention;

FIG. 2 ~~is~~ shows a front elevational view of the device of;

FIG. 1; and ~~3~~ shows a top view.

FIG. 3 is a top plan view of the device of FIG. 1.

### Detailed Description of the Invention

A device for the production of filled and sealed containers, for example, ampules filled with a pharmaceutical preparation, according to an embodiment of the present invention, has a first rack 1 bearing the extruders ~~extruder~~ 2, which can have a varied size, as shown in FIG. 3. In the exemplary embodiment, ~~there is a larger extruder is~~ between two smaller extruders. The extruders 2 are all at the height of the extrusion head 3 which, on its bottom, has an outlet opening for a tube. ~~The Furthermore the~~ extrusion head 3 is made such that coextrusion of three layers which jointly form the tube is possible. The tube head 3 is securely connected to the rack 1 by ~~way of the~~ extruders 2.

A second rack 4 is connected to that side of the frame or rack 1 above which the extruders 2 project. ~~The~~ the rack 4 bears two blow-fill-seal means at a distance adjacent to each other, and both are made the same. Each of these two means has a blow mold ~~which is~~ divided in the vertical direction and positionable ~~which can be positioned~~ underneath the extrusion head 3.

After the tube emerging from the extrusion head 3 has reached a length such that its lower end extends to the lower end of the blow mold, the mold ~~latter~~ is closed. Instead of blowing the ampule or the ampules, filling and then sealing them in this position of the blow mold, as is conventional in the known devices, in the exemplary embodiment the tubing is cut off above the

blow mold. ~~The and the~~ blow mold is moved from its position underneath the extruder head to a side ~~initial~~ position underneath the associated blowing and filling device 5. The two blowing and filling devices 5 are located, as shown in FIGS. 2 and 3, next to one side or the other of the extrusion head 3. At this point, the other blow mold is moved into the position underneath the extrusion head 3 at the same time in order to be able to accommodate an extruded tube there. Air, ~~and air~~ for the blowing process is forced into the tube located in the other blow mold. This is followed by adding the contents through the still open head of the ampule or ampules. Only when filling is ended are the parts of the blow mold which mold the head moved together and the head of the ampule or ampules is/are finish-molded and sealed. Correspondingly, after the other blow mold has been pushed back into its initial position, one or more ampules are blown from the tube located in it and they are then filled and sealed.

The contents of the ampules are protected both against moisture and also against oxygen, because one of the layers comprising the wall of the ampules prevents oxygen from diffusing through. ~~The and the~~ other two layers form a water vapor barrier. Therefore, the ampules, after they have been ejected and excess plastic parts have been removed, need not be provided with barrier-forming repackaging. The two conveyor means 6 with which the finished ampules are removed are shown schematically in FIG. 3 ~~and labeled 6~~.

The power supply of all assemblies takes place by ~~way of~~ a control cabinet 7 which also contains all the controls. The control cabinet 7 is a separate component which can be set up wherever this is most advantageous. In the exemplary embodiment, the control cabinet 7 is next to the first rack 1 connected to the back of the second rack 4.

All features mentioned in the above specification as well as those that can be taken only from the drawing are components of the present invention as further embodiments, even if they are not particularly emphasized and not specifically mentioned in the claims.



While one embodiment has been chosen to illustrate the invention, it will be understood by those skilled in the art that various changes and modifications can be made therein without departing from the scope of the invention as defined in the appended claims.

— Claims

What is claimed is:

METHOD AND DEVICE FOR THE PRODUCTION  
OF FILLED AND SEALED CONTAINERS

Abstract of the Disclosure

1. ~~\_\_\_\_\_ A method and a device~~ Method for the production of filled and sealed containers involves in which

~~\_\_\_\_\_ a) \_\_\_\_\_ a plastic tube that~~ is extruded,

~~\_\_\_\_\_ b) \_\_\_\_\_ at least one container which is impermeable to vapour~~ water vapor and which is provided with one filling a fill opening formed is molded from this plastic tube,

~~\_\_\_\_\_ c) the filling product being introduced into the \_\_\_\_\_ contents \_\_\_\_\_ are~~ added to this container through the filling fill opening and subsequently then

~~\_\_\_\_\_ d) \_\_\_\_\_ the filling opening being~~ is sealed by welding. The;

~~\_\_\_\_\_ characterized in that the tube is made of \_\_\_\_\_ formed from at least one layer making~~ which makes the container impermeable to oxygen.

2. ~~\_\_\_\_\_ The process as claimed in claim 1, wherein to form the tube at least two, preferably up to six layers are coextruded, of which at least one forms the barrier layer which is impermeable to oxygen.~~

3. ~~\_\_\_\_\_ Device for executing the process as claimed in claim 2, wherein it has at least two racks (1, 4), of which one bears an extrusion head (3) and for each intended layer an extruder (2) and the other bears at least one blow fill seal means (5).~~

4. ~~The device as claimed in claim 3, characterized by a control cabinet (7) made as a separate unit.~~